

Date: Thursday, 3/20/2008 9:54:22 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TURNING DETAIL FOR D2893-1
Job Number : 38131	
Estimate Number : 13234	
P.O. Number :	Part Number : DSK078
This Issue : 3/20/2008 S.O. No. :	Drawing Number : DSK078 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : A
Previous Run :	Material :
Written By :	Due Date : 4/3/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JA 08 03 20</u>	
Comment : est rev A 08.03.13 new issue EC	

Additional Product

Job Number:



Seq. # Machine Or Operation: Description :

1.0 D6104005 17-4 SS Roundbar 4.00"OD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
Support

B 38211 RP 08/04/07

2.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE
Turn blank as per Folio FA081

RP 08/04/07

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

RP 08/04/07

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

RP 08/04/11

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock in Kanban
Location: CNC

RP 08/04/11 (9)

6.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/14 JA

Job Completion



JA cmf 08-04-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

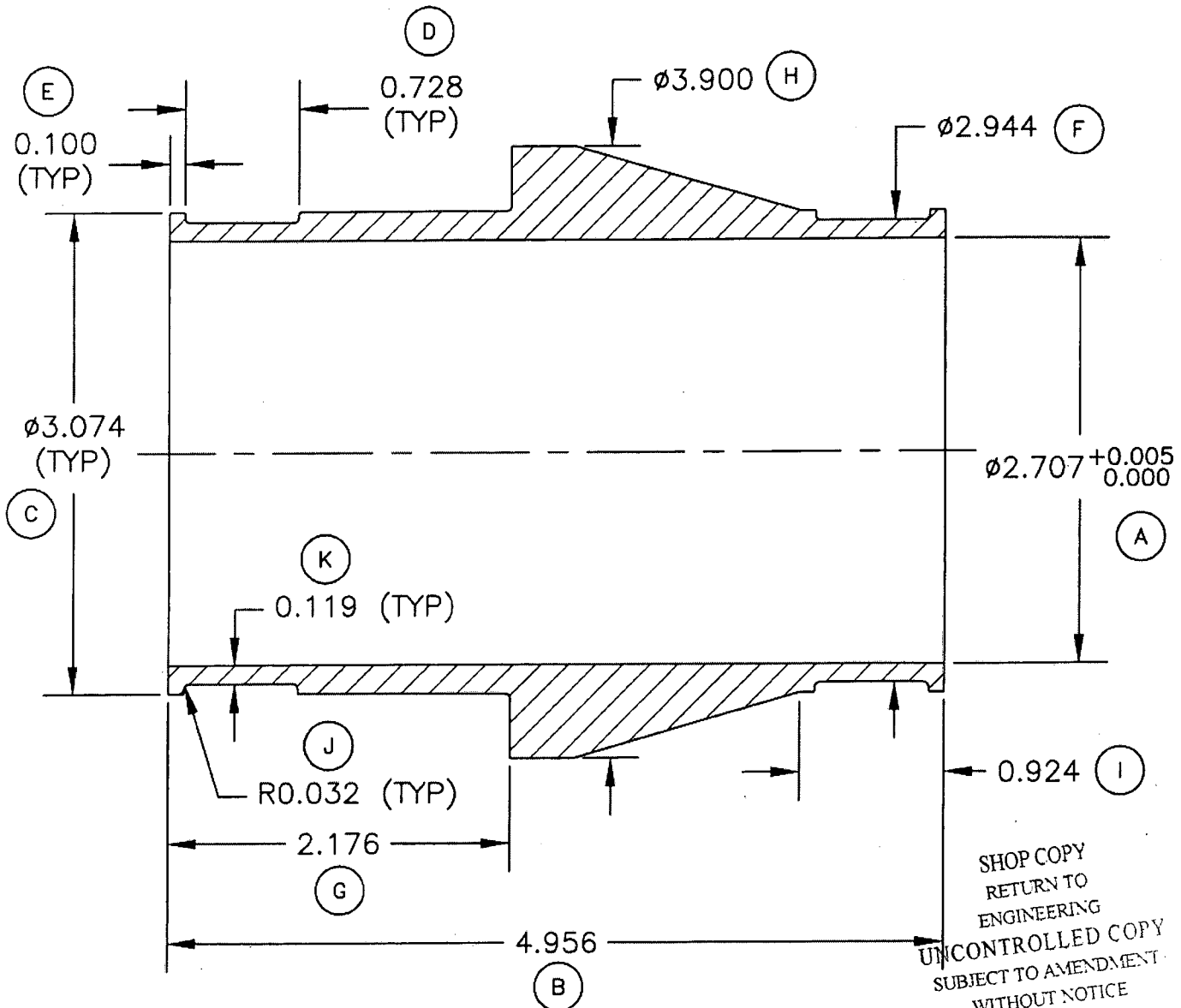
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSK 078	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2893-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01



D2893-1 TURNING DETAIL

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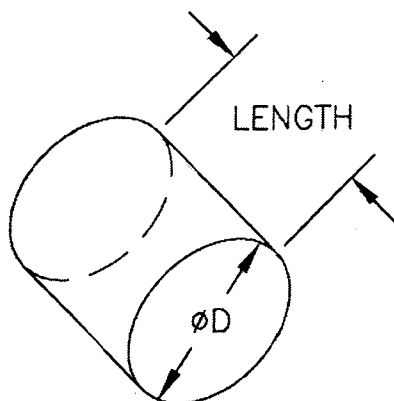


DESIGN LH	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D6104	Rev. B SHEET 1 OF 1
DATE 02.11.25		TITLE ROUND BILLET, 17-4	SCALE NTS
A	01.04.10	NEW ISSUE	
B	02.11.25	CLARIFY ALLOY SPEC ADDED D6104-009/-011 REDUCE LENGTH OF BILLETS	

RELEASED

02.11.25

SPECIFICATION CONTROL DRAWING



MATERIAL: 17-4 PH SS (AMS 5643 OR AISI 630) MIN UTS = 170 KSI (38 HRc)

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, DIAMETER x LENGTH (+0.030/-0.000) AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES

Part No.	Alloy	D (Diameter)	Length
D6104-001	17-4 PH STAINLESS STEEL	Ø3.00	3.80
D6104-003	17-4 PH STAINLESS STEEL	Ø3.25	3.80
D6104-005	17-4 PH STAINLESS STEEL	Ø4.00	5.10
D6104-007	17-4 PH STAINLESS STEEL	Ø4.50	5.10
D6104-009	17-4 PH STAINLESS STEEL	Ø5.25	4.10
D6104-011	17-4 PH STAINLESS STEEL	Ø6.50	4.10

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DART AEROSPACE LTD	Work Order:	38131
Description: Ø2.750 Support	Part Number:	D2893-1
Inspection Dwg: D2893 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2893 Rev B / DSK078 Rev A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
Lathe Section									
A	2.707	2.712		2.712	2.712	2.712	2.712		
B	4.946	4.966		4.956	4.956	4.956	4.956		
C	3.064	3.084		3.074	3.074	3.074	3.074		
D	0.718	0.738		.728	.728	.728	.728		
E	0.090	0.110		.100	.100	.100	.100		
F	2.934	2.954		2.944	2.944	2.944	2.944		
G	2.166	2.186		2.176	2.176	2.176	2.176		
H	3.890	3.910		3.900	3.900	3.900	3.900		
I	0.914	0.934		.924	.924	.924	.924		
J	0.022	0.042		.032	.032	.032	.032		
K	0.109	0.129		.119	.119	.119	.119		
L									
HAAS Section									
AA	2.985	3.005							
AB	0.440	0.460							
AC	0.125	0.160							
AD	0.040	0.060							
AE	0.188	0.193							
AF	0.125	0.160							
AG	0.140	0.160							
AH	1.360	1.400							
AI	0.040	0.060							
AJ	1.190	1.230							
AK	0.010	0.020							
AL	0.053	0.073							
AM	0.240	0.260							
AN	2.518	2.538							
AO	84.39	90.39							
AP	0.261	0.266							
AQ	0.053	0.073							
AR									
AS									
Accept/Reject									

Measured by: 20
Date: 08/04/11

Audited by: ST
Date: 08/04/11

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	

DART AEROSPACE LTD	Work Order:	38131
Description: Ø2.750 Support	Part Number:	D2893-1
Inspection Dwg: D2893 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2893 Rev B / DSK078 Rev A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
Lathe Section									
A	2.707	2.712		2.712	2.712	2.712	2.712		
B	4.946	4.966		2.956	2.956	2.956	2.956		
C	3.064	3.084		3.074	3.074	3.074	3.074		
D	0.718	0.738		.728	.728	.728	.728		
E	0.090	0.110		.100	.100	.100	.100		
F	2.934	2.954		2.944	2.944	2.944	2.944		
G	2.166	2.186		2.174	2.174	2.174	2.174		
H	3.890	3.910		3.900	3.900	3.900	3.900		
I	0.914	0.934		.924	.924	.924	.924		
J	0.022	0.042		.032	.032	.032	.032		
K	0.109	0.129		.119	.119	.119	.119		
L									
HAAS Section									
AA	2.985	3.005							
AB	0.440	0.460							
AC	0.125	0.160							
AD	0.040	0.060							
AE	0.188	0.193							
AF	0.125	0.160							
AG	0.140	0.160							
AH	1.360	1.400							
AI	0.040	0.060							
AJ	1.190	1.230							
AK	0.010	0.020							
AL	0.053	0.073							
AM	0.240	0.260							
AN	2.518	2.538							
AO	84.39	90.39							
AP	0.261	0.266							
AQ	0.053	0.073							
AR									
AS									
Accept/Reject									

Measured by: RO
Date: 08/04/11

Audited by: SR
Date: 08/04/11

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	

DART AEROSPACE LTD	Work Order: 38131
Description: Ø2.750 Support	Part Number: D2893-1
Inspection Dwg: D2893 Rev. B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2893 Rev B / DSK078 Rev A and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
Lathe Section									
A	2.707	2.712		2.712	2.712	2.712	2.712		
B	4.946	4.966		4.955	4.955	4.955	4.955		
C	3.064	3.084		3.074	3.074	3.074	3.074		
D	0.718	0.738		.728	.728	.728	.728		
E	0.090	0.110		.100	.100	.100	.100		
F	2.934	2.954		2.944	2.944	2.944	2.944		
G	2.166	2.186		2.176	2.176	2.176	2.176		
H	3.890	3.910		3.900	3.900	3.900	3.900		
I	0.914	0.934		.924	.924	.924	.924		
J	0.022	0.042		.032	.032	.032	.032		
K	0.109	0.129		.119	.119	.119	.119		
L									
HAAS Section									
AA	2.985	3.005							
AB	0.440	0.460							
AC	0.125	0.160							
AD	0.040	0.060							
AE	0.188	0.193							
AF	0.125	0.160							
AG	0.140	0.160							
AH	1.360	1.400							
AI	0.040	0.060							
AJ	1.190	1.230							
AK	0.010	0.020							
AL	0.053	0.073							
AM	0.240	0.260							
AN	2.518	2.538							
AO	84.39	90.39							
AP	0.261	0.266							
AQ	0.053	0.073							
AR									
AS									
Accept/Reject									

Measured by: RD
Date: 08/04/11

Audited by: RF
Date: 08/04/11

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	

DART AEROSPACE LTD	Work Order:	38131
Description: Ø2.750 Support	Part Number:	D2893-1
Inspection Dwg: D2893 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2893 Rev B / DSK078 Rev A and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
Lathe Section									
A	2.707	2.712		2.712	2.712	2.712	2.712		
B	4.946	4.966		4.956	4.956	4.956	4.956		
C	3.064	3.084		3.074	3.074	3.074	3.074		
D	0.718	0.738		.728	.728	.728	.728		
E	0.090	0.110		.100	.100	.100	.100		
F	2.934	2.954		2.944	2.944	2.944	2.944		
G	2.166	2.186		2.176	2.176	2.176	2.176		
H	3.890	3.910		3.900	3.900	3.900	3.900		
I	0.914	0.934		.924	.924	.924	.924		
J	0.022	0.042		.032	.032	.032	.032		
K	0.109	0.129		.119	.119	.119	.119		
L									
HAAS Section									
AA	2.985	3.005							
AB	0.440	0.460							
AC	0.125	0.160							
AD	0.040	0.060							
AE	0.188	0.193							
AF	0.125	0.160							
AG	0.140	0.160							
AH	1.360	1.400							
AI	0.040	0.060							
AJ	1.190	1.230							
AK	0.010	0.020							
AL	0.053	0.073							
AM	0.240	0.260							
AN	2.518	2.538							
AO	84.39	90.39							
AP	0.261	0.266							
AQ	0.053	0.073							
AR									
AS									
Accept/Reject									

Measured by:	RO
Date:	08/04/11

Audited by:	RF
Date:	08/04/11

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	

DART AEROSPACE LTD	Work Order: 3831
Description: Ø2.750 Support	Part Number: D2893-1
Inspection Dwg: D2893 Rev. B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2893 Rev B / DSK078 Rev A and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
Lathe Section									
A	2.707	2.712		2.712	2.712	2.712	2.712		
B	4.946	4.966		4.956	4.956	4.956	4.956		
C	3.064	3.084		3.074	3.074	3.074	3.074		
D	0.718	0.738		.728	.728	.728	.728		
E	0.090	0.110		.100	.100	.100	.100		
F	2.934	2.954		2.944	2.944	2.944	2.944		
G	2.166	2.186		2.176	2.176	2.176	2.176		
H	3.890	3.910		3.900	3.900	3.900	3.900		
I	0.914	0.934		.924	.924	.924	.924		
J	0.022	0.042		.032	.032	.032	.032		
K	0.109	0.129		.119	.119	.119	.119		
L									
HAAS Section									
AA	2.985	3.005							
AB	0.440	0.460							
AC	0.125	0.160							
AD	0.040	0.060							
AE	0.188	0.193							
AF	0.125	0.160							
AG	0.140	0.160							
AH	1.360	1.400							
AI	0.040	0.060							
AJ	1.190	1.230							
AK	0.010	0.020							
AL	0.053	0.073							
AM	0.240	0.260							
AN	2.518	2.538							
AO	84.39	90.39							
AP	0.261	0.266							
AQ	0.053	0.073							
AR									
AS									
Accept/Reject									

Measured by: RQ
Date: 08/04/11

Audited by: [Signature]
Date: 08/04/11

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	[Signature]

DART AEROSPACE LTD	Work Order: 38131
Description: Ø2.750 Support	Part Number: D2893-1
Inspection Dwg: D2893 Rev. B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2893 Rev B / DSK078 Rev A and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
Lathe Section									
A	2.707	2.712		2.712	2.712	2.712	2.712		
B	4.946	4.966		4.956	4.956	4.956	4.956		
C	3.064	3.084		3.074	3.074	3.074	3.074		
D	0.718	0.738		.728	.728	.728	.728		
E	0.090	0.110		.100	.100	.100	.100		
F	2.934	2.954		2.944	2.944	2.944	2.944		
G	2.166	2.186		2.176	2.176	2.176	2.176		
H	3.890	3.910		3.900	3.900	3.900	3.900		
I	0.914	0.934		.924	.924	.924	.924		
J	0.022	0.042		.032	.032	.032	.032		
K	0.109	0.129		.119	.119	.119	.119		
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HAAS Section									
AA	2.985	3.005							
AB	0.440	0.460							
AC	0.125	0.160							
AD	0.040	0.060							
AE	0.188	0.193							
AF	0.125	0.160							
AG	0.140	0.160							
AH	1.360	1.400							
AI	0.040	0.060							
AJ	1.190	1.230							
AK	0.010	0.020							
AL	0.053	0.073							
AM	0.240	0.260							
AN	2.518	2.538							
AO	84.39	90.39							
AP	0.261	0.266							
AQ	0.053	0.073							
AR									
AS									
Accept/Reject									

Measured by: DP
Date: 08/04/11

Audited by: JF
Date: 08/04/11

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	